



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3121-041
Job Sheet 176279



Part No: D3121-041

Job Qty: 4 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/19/18

Job Tracking No:

Due Date: 5/11/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV E IPP Rev:Pick:A 04.02.18 New issue KJ/DS IPP Rev:B ECN 1060 07-11-12 DD verified by: EC
IPP Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	5/11/18	5/11/18	0.00	0.00	Start Up Machining-1		<i>lml</i>
100	Bandsaw	4 pcs	5/11/18	5/11/18	0.00	0.06	Bandsaw1		<i>lml</i>
110	CNC Vertical Machining	4 pcs	5/11/18	5/11/18	0.00	8.01	HAAS1-3		<i>lml</i>
120	QC	4 pcs	5/11/18	5/11/18	0.00	0.00	QC2 Machining-1		<i>lml</i>
130	QC	4 pcs	5/11/18	5/11/18	0.00	0.00	QC8 Machining-1		<i>lml</i>
140	Small Fab	4 pcs	5/11/18	5/11/18	0.00	0.13	Small Fab-2		<i>lml</i>
150	QC	4 pcs	5/11/18	5/11/18	0.00	0.00	QC5		<i>lml</i>
160	Packaging	4 pcs	5/11/18	5/11/18	0.00	0.00	Packaging3-1		<i>lml</i>
170	QC21-SA	4 Ea	5/11/18	5/11/18	0.00	0.00	QC21		<i>lml</i>

Part Op 100 - Cut blanks: (1.000" x 2.000") 3.250" long
Descriptions: 110 - 1-Machine D3121-11 as per Folio FA331 and Dwg D3121 Identify as D3121-11 2-Deburr 3-Scribe batch number
120 - QC2- Inspect parts off machine FAI/FAIB
130 - QC8- Inspect parts - second check
140 - Assemble D3121-141 as per Dwg D3121.
150 - QC5- Inspect part completeness to step on W/O
160 - Location: CA2
170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.250X2.000	17-4 SS Bar 1.250 x 2.00	1.0820 ft (.2705 ea)	90-Start up Operation	
D3121-21	Bolt	4 Ea (1 ea)	140-Small Fab	<i>5037655</i>
D3121-241	Bearing Assembly	4 Ea (1 ea)	140-Small Fab	<i>5037821</i>

5030457 x4

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-B1.250X2.000	1	10	0
140-Small Fab	D3121-21	4	67	0
	D3121-241	4	21	0

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Part Specifications

Specifications could not be found.

Plex 4/19/18 1:01 PM dart.lacelle.linda

DART
AEROSPACE

Container No: S068651



Part: D3121-041

Job No: 176279

Serial No/Batch: S068651

Revision:

Inspector:

1415 PLENUM ROAD
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/04/18

1415 PLENUM ROAD

DQA: _____ Date: _____



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Root Cause				FAULT CATEGORY			
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Past Expiry Date ☐		Manufacturing Process ☐		OTHER : ☐			
Misidentified ☐		Past Due ☐					

DART AEROSPACE LTD		Work Order: 176279
Description: Bracket		Part Number: D3121-11
Inspection Dwg: D3121	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	.394	✓		micrometer	
Ø0.201 x 0.100	+/-0.010	.200	✓		Vernier	
0.75	+/-0.030	.752	✓		Vernier	
0.375	+/-0.010	.375	✓			
1.250	+/-0.010	1.245	✓		highge	
0.300	+/-0.010	.296	✓		Vernier	
1.96	+/-0.030	1.964	✓		Vernier	
Ø0.573	+/-0.010	.5750	✓		Vernier	
0.345	+/-0.010	.344	✓			
0.300	+/-0.010	.300	✓		Vernier	
0.080	+/-0.010	.082	✓		Vernier	
2.56	+/-0.030	2.556	✓		highge	
2.14	+/-0.030	2.110	✓		Vernier	
0.130	+/-0.010	.129	✓		Vernier	
2.57	+/-0.030	2.540	✓		Vernier	
2.85	+/-0.030	2.855	✓		Vernier	
0.381	+/-0.010	.382	✓		Vernier	
0.400	+/-0.010	.396	✓		Vernier	
0.201	+/-0.010	.200	✓		Vernier	
0.580	+/-0.010	.577	✓		Vernier	
0.032	+0.000/-0.010	.025	✓		highge	

Measured by: [Signature]	Audited by: [Signature]	Prototype Approval:	N/A
Date: 2018/05/24	Date: 18-05-07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.01	New Issue P/O D3121-041	KJ/EC/DD	
B	08.06.02	Tolerance revised for Ø0.573	KJ/DD	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

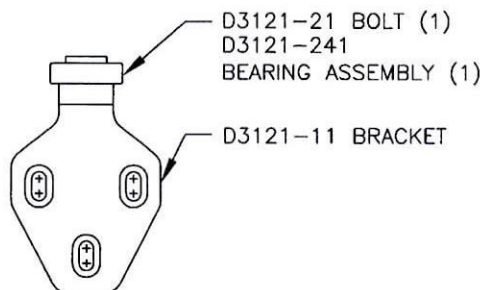
Work Order update only ☐

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

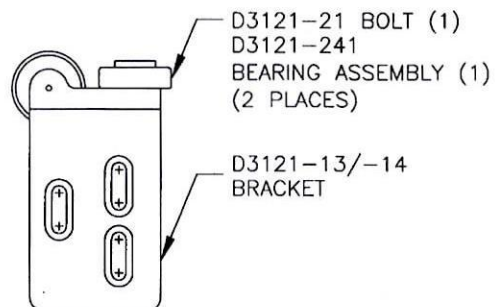


DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 1 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)	

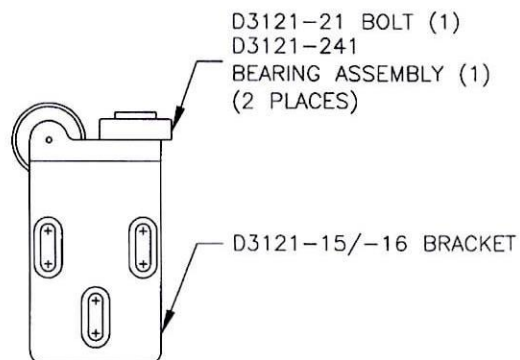
RELEASED
07.11.07



D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-35/-36)

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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